

Date: Tuesday, 10/24/2006 10:58:29 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET LID ASSEMBLY		
Job Number	: 29128A					
Estimate Number	: 10206					
P.O. Number	: N/A			Part Number	: D2989041	
This Issue	: 10/24/2006 S.O. No. : N/A			Drawing Number	: D2989 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: B	
Previous Run	: 29127A			Material	: N/A	
Written By	: <u>dk</u> 06 10 24			Due Date	: 11/20/2006	
Checked & Approved By				Qty:	1 Um: Each	
Comment	: Est Rev:I Removed D2989-043 05-11-03 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31663	Basket Hoop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick:	
		Qty.(1) D3166-3 Batch: <u>B28525</u>	<u>PD</u> <u>06-11-24</u> <u>(1)</u>
2.0	D2581	Mounting Bracket	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part number Description Batch	
		2 D2581 Mounting Brackets <u>B27587</u>	<u>PD</u> <u>06-11-24</u> <u>(1)</u>
3.0	D23273	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part number Description Batch	
		2 D2327-3 Bushing <u>B28073</u>	<u>PD</u> <u>06-11-24</u> <u>(1)</u>
4.0	D2506	Placard	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick:	
		Qty Part number Description Batch	
		1 D2506 Label Plate <u>B27217</u>	<u>PD</u> <u>06-11-24</u> <u>(1)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
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5.0	M304EX07516F	Expanded Metal Flat Stai
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Comment: Qty.: 15.0000 sf(s)/Unit Total : 15.0000 sf(s)

Pick:

Qty	Part number	Description	Batch
15sf	M304EX0.75-16F	Expanded Metal	M102394

PD

06-11-24

6.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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Comment: Qty.: 31.7709 f(s)/Unit Total : 31.7709 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SStubing.

Batch: M102502

PD

06-11-24 (1)

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

2-Drill holes in tubing as D2989-041 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

5-Drill Ø0.257" hole as D2989-041 per Dwg D2989 Identify as D2989-041

PD

06-11-24 (1)

8.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

06-11-24 (1)

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

06-11-24 (1)

10.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

AM 06/11/27 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/12/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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2-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4

Spray Paint Black: M102615

Wing Walk: 102098

a.m.Y/ 06/11/27

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

SB 06/11/27

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 06/12/28

Job Completion



U No. 11. 28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

RELEASED

05-08-19

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
X		D2989-043	BASKET LID ASSEMBLY (INSIDE)
1		D2989-1	STRUT
1		D2989-2	STRUT
1		D2989-3	STRUT
1		D2989-4	STRUT
2		D2989-5	STRUT
2		D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
2		D3182-1	HINGE
2		D3442-3	SHIM

SHOP COPY

RETURN TO

ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

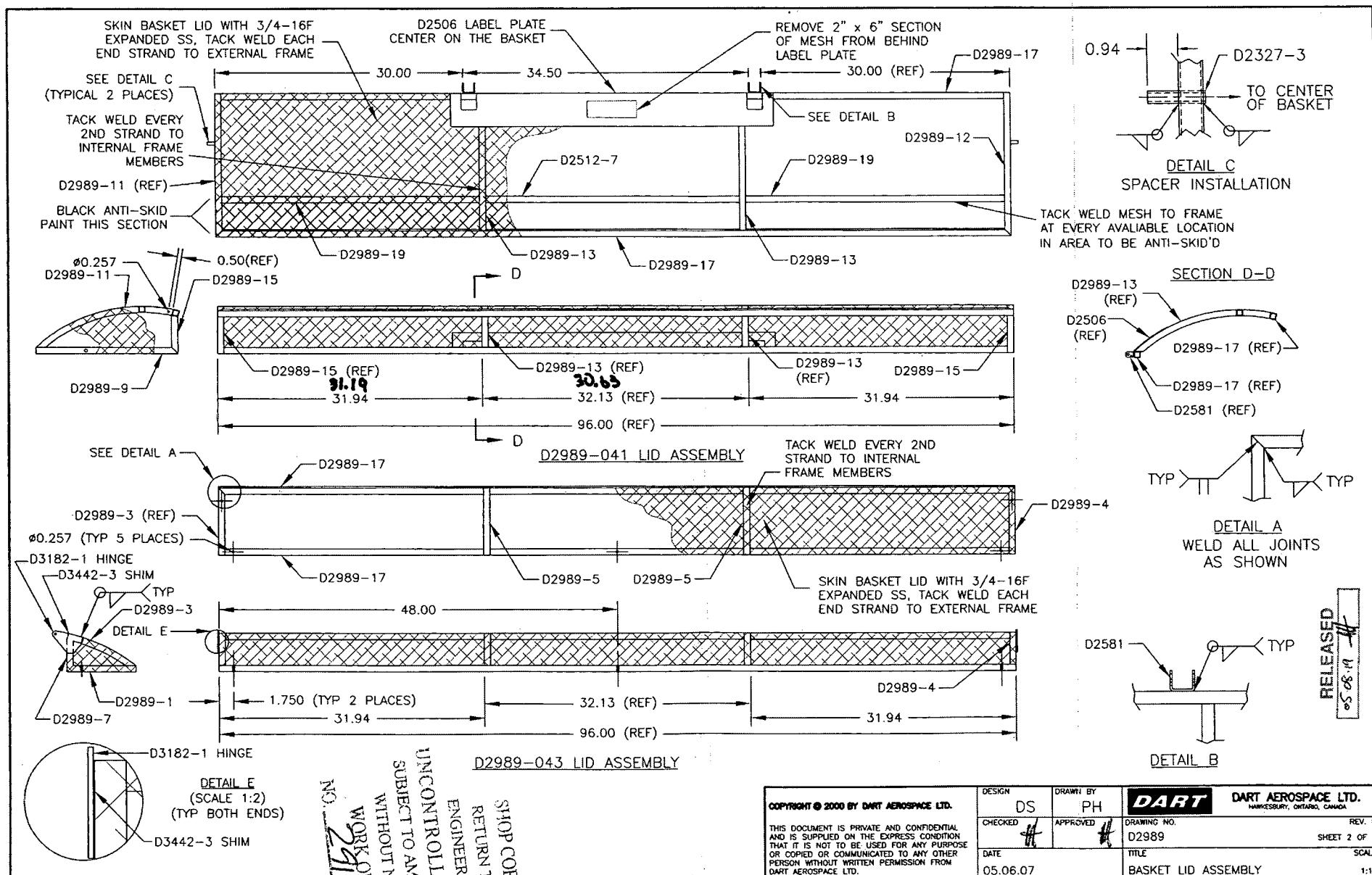
29128A

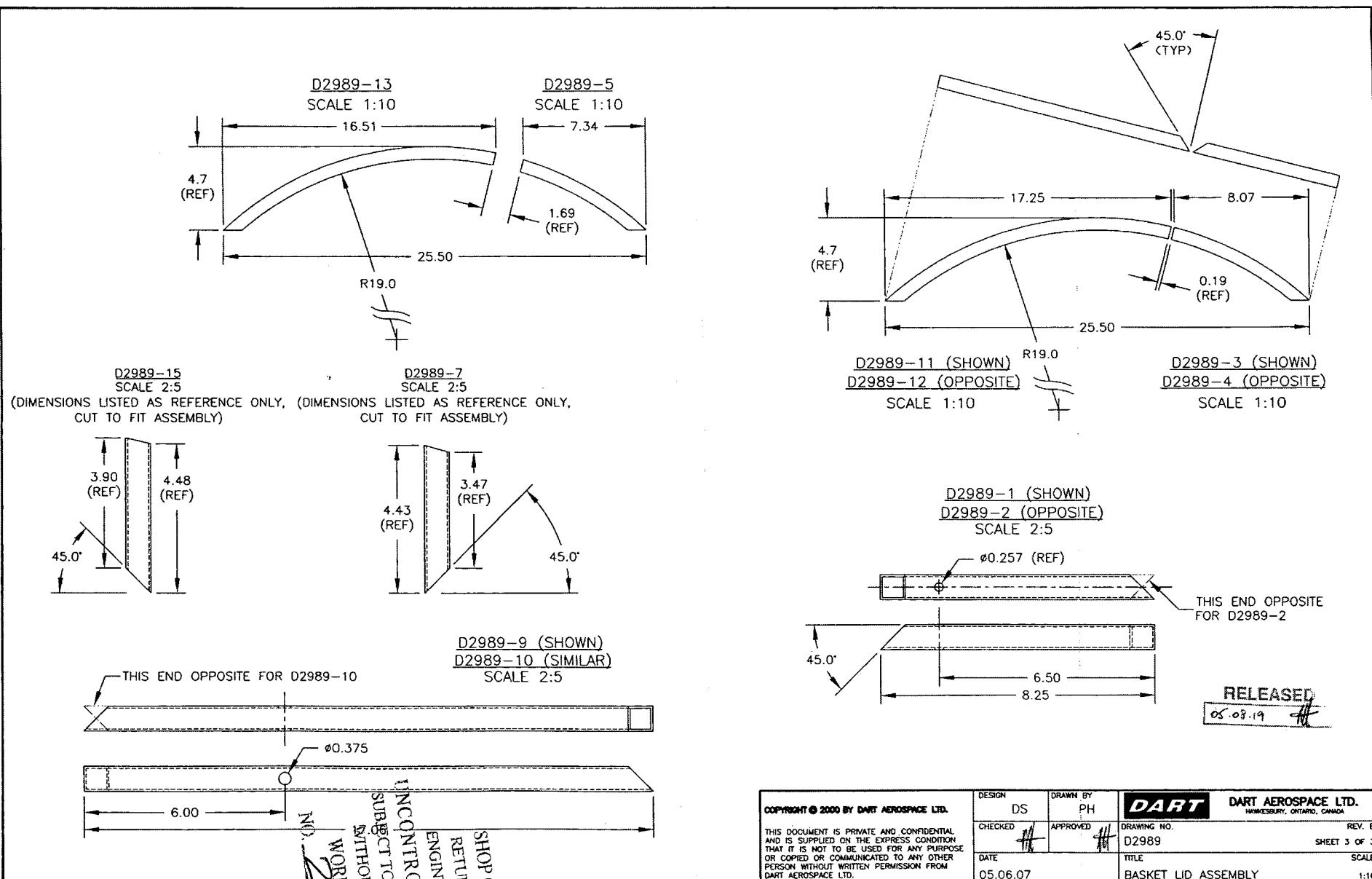
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT COPIED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO.	D2989	REV. B	
				DATE	05.06.07	SHEET 3 OF 3	SCALE 1:10
				TITLE	BASKET LID ASSEMBLY		